

54305 DeRen

Work Order ID 54184

December 2, 2009 11:15:00 AM



Item ID: D044-717-011
Revision ID: N/A
Item Name: Cold Weather Baffle

Accept



Setup Start



Stop



Start Date: 12/02/09 Start Qty: 4.00
Required Date: 12/04/09 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date:
QC: *[Signature]* Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

11N-D044-717 Rev *B*

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D044-717-011CHG001

Ser/12/04

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

⇒ Ser/12/04

11/12/04 (2)

(12) ✓

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Start Date: 12/02/09 Start Qty: 4.00
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Cust Item ID:
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Date:
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Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D044-717-011

Location:

PPP Rev:

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

9/12/09 4 @ SP

09/12/08 HJ

UMF 09-12-07

Picklist Print

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Work Order ID: 54184

Parent Item: D044-717-011RevN/A

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 12/02/09

Required Date: 12/04/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3276-041RevB		Manufactured	No			110	Each	6.0000	2.0000			
Baffle Assembly LH												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
52373	6	

D3276-042RevB		Manufactured	No			110	Each	2.0000	4.0000			
Baffle Assembly RH												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
52374	2	

D3383-1RevA		Manufactured	No			110	Each	9.0000	4.0000			
Placard												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
39690	1	
52723	8	

52373

52374

52723

12/4/09 (2)

Picklist Print

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Work Order ID: 54184

Parent Item: D044-717-011RevN/A

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 12/02/09

Required Date: 12/04/09

Start Qty: 4.00 2

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R7 8x Purchased No



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

152

104394

3

113064

100

113096

49

MS20426AD3-4 1/16" Purchased No



RIVET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7797

104374

3797

110398

4000

MS21059L3 3/8" Purchased No



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

212

109962

11

111925

201

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Shop Packet Print

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2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

5.0 PARTS LIST

Qty	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE